

# Work Order ID 71874

Wednesday, August 17, 2011 11:24:41 AM



Page 1

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Item Name: Saddle RH Out, 206

Stop



Start Date: 7/14/2011 Start Qty: 6.00

Required Date: 7/28/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

EDUPLICATE!

Reference:

Approvals:

Process Plan: *cmf*

Date: 11-08-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2938	Rev C

100

0.00



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

0.00

0.00

0.00

0.00

0.00

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

120



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

*cmf* / *B.A.* 11/08/22

*cmf* / *B.A.* 11/08/22

*cmf* / *B.A.* 11/08/22

10

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

SL

11-08-23



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø M-11/08/24

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

2:45

3:15

10X Ø M-11/08/24

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71874**

Wednesday, August 17, 2011 11:24:41 AM



Page 3

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10	10R	11-8-24	
170 	Identify as per dwg & Stock Location 428A	0.00							
Packaging Packaging	Memo	0.00							11/8/24 J (102)
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/8/25 J

ME

11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 17, 2011 11:24:37 AM

Page 1

Work Order ID: 71874



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC ☐  
IPP Rev: C As per Rev C 07-03-19 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	40.0000	1	6			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	20	
72226	20	
MAT44	20	
✓ 72226	20	

10.0

B.A 11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries.



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71874
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.103	0.105	.103	.108		
B	0.100	0.140		0.112	0.111	.107	.103		
C	0.100	0.140		0.118	0.116	.103	.110		
D	0.210	0.230		0.218	0.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.570	.571	.571	.571		
I	1.572	1.582		1.577	1.577	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	.258	.258		
L	0.312	0.317		0.314	0.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		0.110	0.109	.109	.109		
O	0.540	0.560		0.549	0.549	.550	.551		
P	0.490	0.510		0.501	0.502	.500	.501		
Q	3.715	3.725		3.720	3.720	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.244	0.250	.247	.247		
T	0.100	0.180		0.130	0.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.368		
W	0.316	0.321		0.317	0.317	.317	.317		
X	1.250	1.270		1.2657	1.261	1.262	1.262		
Y	1.565	1.585		1.580	1.5746	1.5746	1.576		
Z	0.178	0.198		0.188	0.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	B.A. / [Signature]
Date:	11/08/22

Audited by:	[Signature]
Date:	11-08-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	71874
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		.107	.106	.105	.106		
B	0.100	0.140		.107	.105	.105	.108		
C	0.100	0.140		.112	.113	.113	.114		
D	0.210	0.230		.220	.220	.218	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	1.250		
H	0.510	0.515		.511	.511	.512	.511		
I	1.572	1.582		1.575	1.578	1.575	1.577		
J	2.495	2.505		2.498	2.500	2.498	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.237	.238		
N	0.100	0.140		.109	.109	.109	.109		
O	0.540	0.560		.551	.549	.548	.548		
P	0.490	0.510		.501	.501	.501	.500		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.246	.248	.247	.248		
T	0.100	0.180		.130	.130	.130	.132		
U	1.625	1.635		1.628	1.630	1.628	1.630		
V	1.362	1.372		1.368	1.367	1.368	1.368		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.263	1.261	1.267	1.261		
Y	1.565	1.585		1.578	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	mf
Date:	11/08/22

Audited by:	st
Date:	11-08-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71874
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	X9	X10	#	A		
A	0.100	0.140		.109	.109				
B	0.100	0.140		.109	.107				
C	0.100	0.140		.115	.114				
D	0.210	0.230		.217	.216				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.51	.51				
I	1.572	1.582		1.578	1.578				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.109	.107				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.719	3.719				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.250	.248				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.258	1.258				
Y	1.565	1.585		1.573	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: 11/08/22

Audited by: <i>SL</i>
Date: 11-08-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>RF</i>

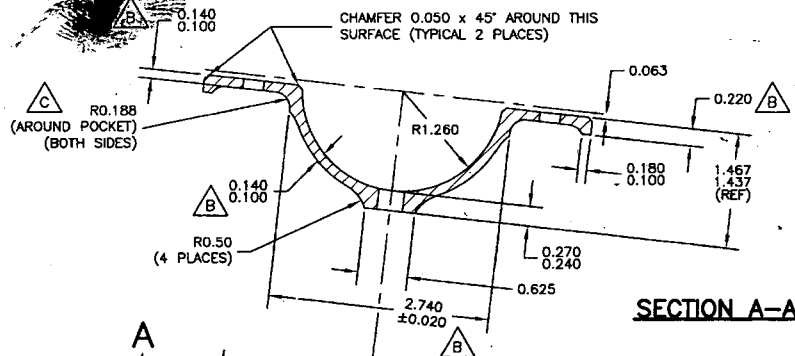
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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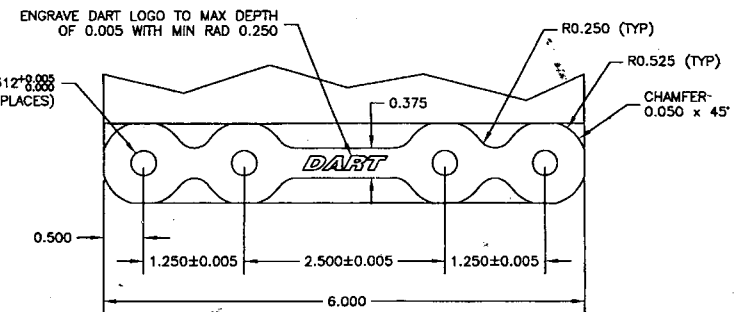
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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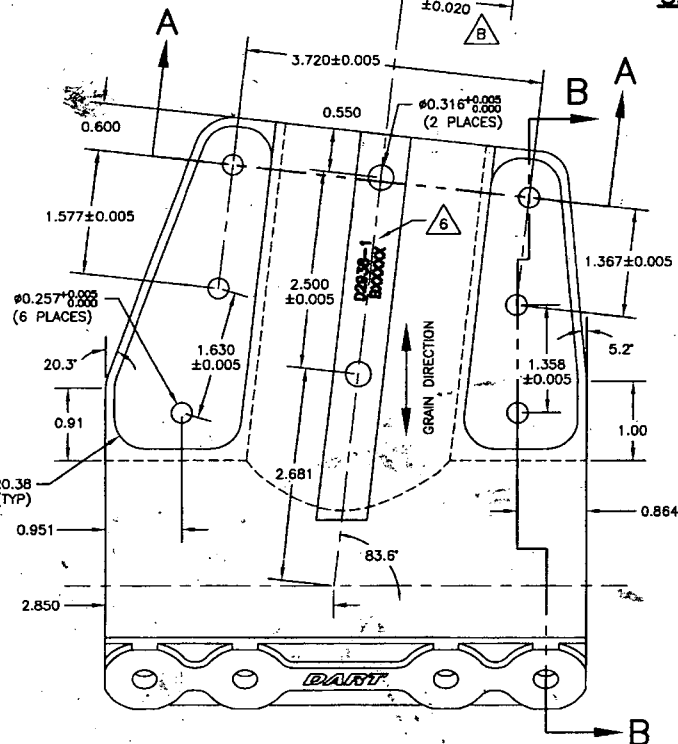
**NOTE:** Date & initial all entries



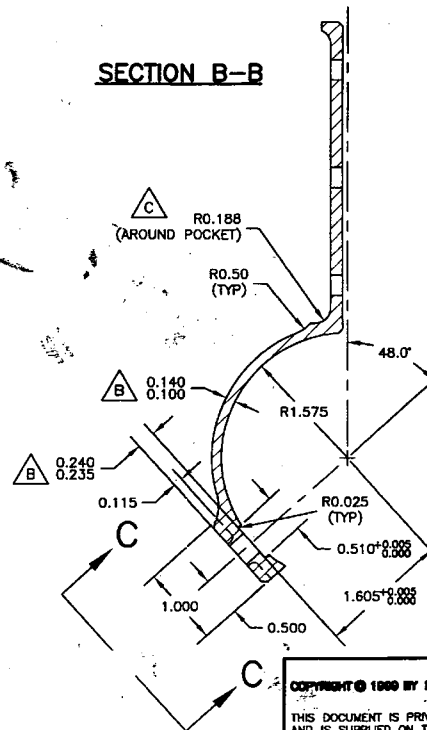
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2938
DATE	06.11.09	SADDLE OUTSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

07.02.12

REV. C  
SHEET 1 OF 1  
SCALE  
2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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